

Date: Monday, 14/11/2005 8:21:44 AM
User: Alba Panzuto

Process Sheet

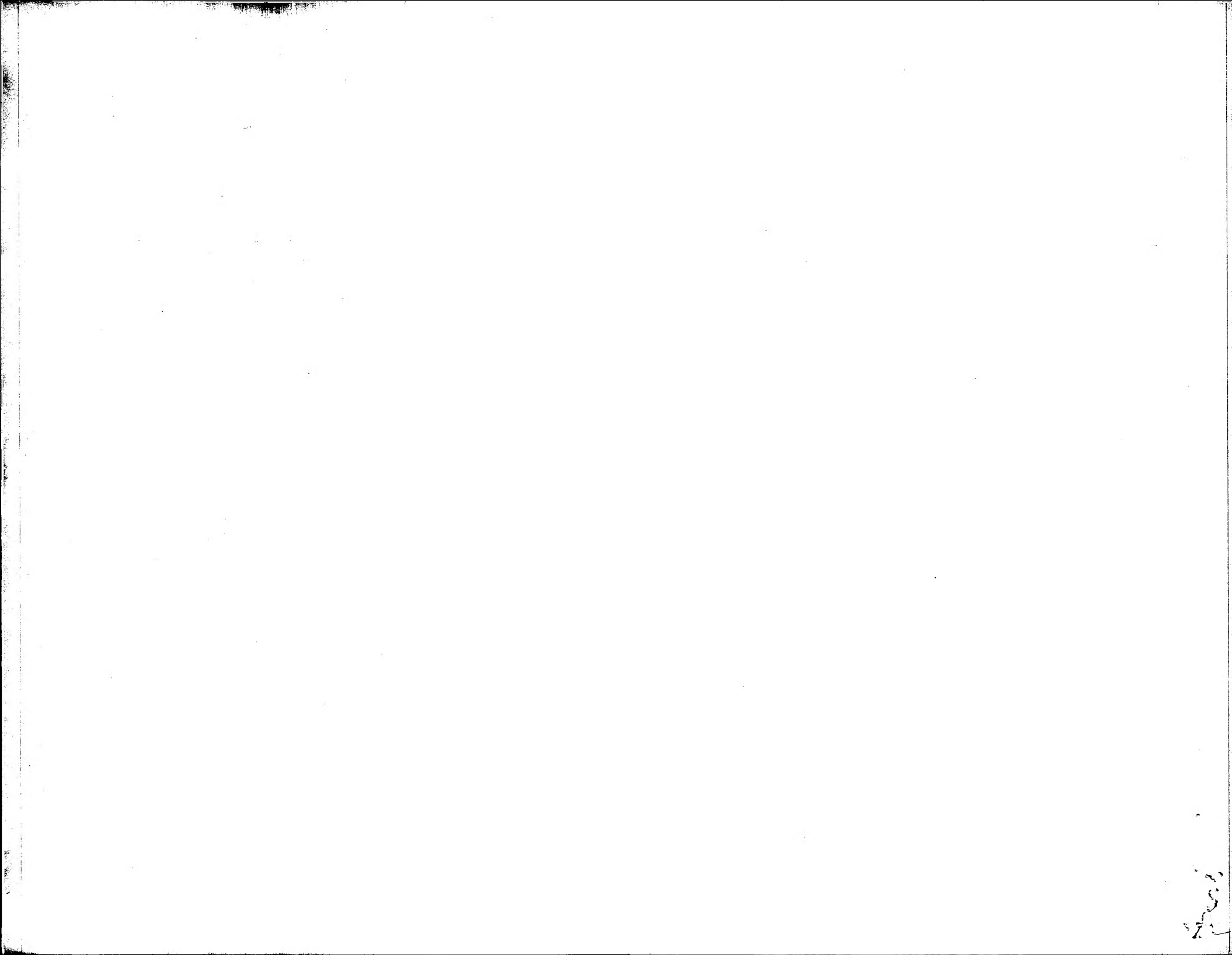
Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BUSHING
Job Number : 24400	
Estimate Number : 10308	
P.O. Number : N/A	Part Number : D26173
This Issue : 14/11/2005 S.O. No. : N/A	Drawing Number : D2617 REV D2
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : D2
Previous Run : N/A	Material : p1A
Written By : <u>See comment below</u>	Due Date : 15/12/2005 Qty: 50 Um: Each
Checked & Approved By : <u>See comment below</u>	
Comment : Est G 04.07.14 Reformat; added step 5 KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6T0375W058	6061-T6 Tube .375 x.058W	M19051 7ml 05/11/23 50
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
Comment: HARDINGE Turn as per Folio FA437 and Dwg D2617 HARDINGE BG 05.11.23			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE 7ml 05/11/23 50			
4.0	QC8	SECOND CHECK J.L	05/11/23 50
Comment: SECOND CHECK 05/11/23 50			
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr break all unmarked sharp edges 0.005 to 0.010 DL 05/11/23 50			
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
Comment: Acid etch and Alodine as per QSI 005 4.1 SAD 05/11/23 50			
7.0	QC5	INSPECT WORK TO CURRENT STEP	
Comment: INSPECT WORK TO CURRENT STEP J.L 11.28 50			



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Drawing Name: BUSHING

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Job Number:



Seq. #:

Machine Or Operation:

Description :

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 49

C20511128

(50)

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

545 05/11/29

(50)

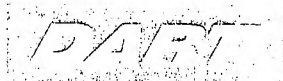
127

05/11/29 (50)

Job Completion

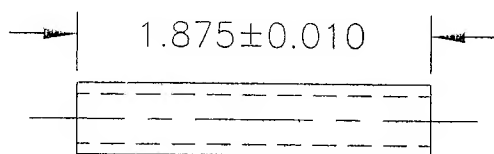


CONTROLLED COPY

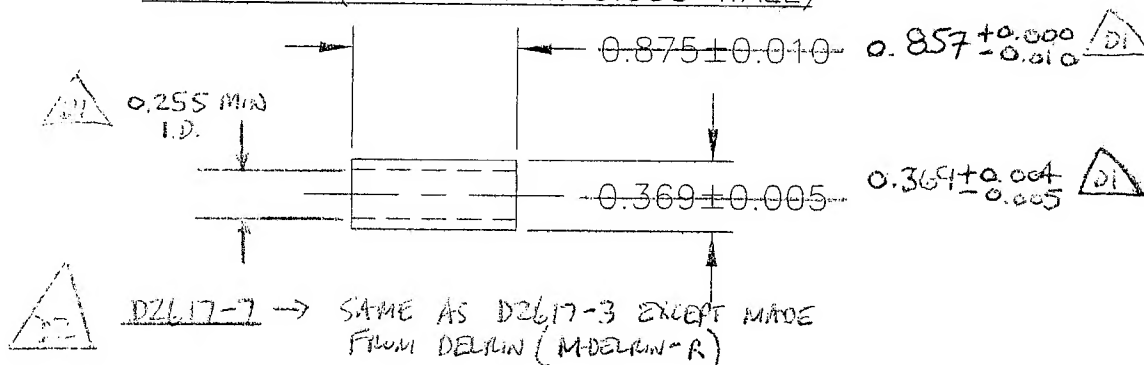


DESIGN BW	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2617	REV. D SHEET 1 OF 1
DATE 01.07.04	TITLE BUSHING SCALE 1:1		
A	96.10.08	NEW ISSUE	
B	97.05.08	.875 WAS 1.125	
C	97.06.04	0.369 DIA WAS 0.375	
D	01.07.04	ADD MAT'L SPEC AND TOL./DIM. NOTE	
DI	CP	04.07.12	CORRECT TOLERANCE (ACR 779)

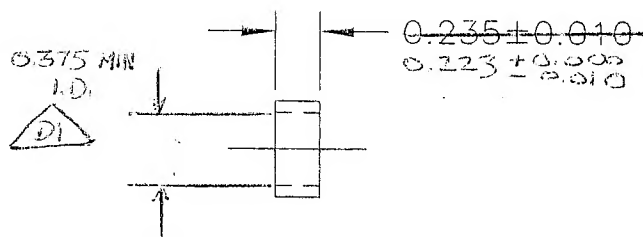
D2617-1 (0.375 OD x 0.058 WALL)



D2617-3 (0.375 OD x 0.058 WALL)



D2617-5 (0.500 OD x 0.058 WALL)



NOTES:

- 1) MATERIAL: 5052-H32 (QQ-A-225/7 OR WW-T-700/4)
OR 6061-T6 (QQ-A-225/8, QQ-A-200/8, OR WW-T-700/6)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH, ALODINE PER QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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DART AEROSPACE LTD		Work Order:	24400
Description: BUSHING		Part Number:	D2617-3
Inspection Dwg: D2617	Rev: D1	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

[illegible]

Measured by: <i>Jml</i>		Audited by: <i>En</i>		Prototype Approval:	
Date: <i>05/11/23</i>		Date: <i>05/11/23</i>		Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 08, 2005
12:06 pm

Work Order No : 0024400
Project Name : D2617-3
Project For : WK542
Work Order Type : Main
Main WO Number :
House Part Number : D2617-3
Description : Bushing
Manufactured : Yes
Amount Req'd : 50
Amount Done : 0
Start Date : 10-03-05
Est Finish Date : 10-20-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00	0.00	0.00
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	2.25	100.00	0.00	0.00
Production Cost	0.00	44.03	100.00	0.00	44.03
Packaging Hours	0.00	0.00	0.00	0.00	0.00
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00	0.00	0.00
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	1.75	100.00	0.00	0.00
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00	0.00	0.00
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	44.03	100.00		
Margin	0.000	0.000			
Selling Cost	0.00	44.03			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	(-44.03)

MIS 2/13
11.13